

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002589**Date Inspected:** 01-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

**Bay 3 – New Tower Building**

The QA Inspector observed ZPMC qualified welder Xu Guoyin ID 05944 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP006-002.

The deck panel repair welding in the progress generally appeared to conform to contract specifications.

The QA Inspector completed documenting the ZPMC deck panel weld repair locations performed to DP018-002.

The QA Inspector inventoried and located the following 16 deck panels in New Tower Building Bay #3 on this date: DP058-001, DP059-001, DP063-001, DP020-001 DP018-002, DP006-002, DP049-001, DP004-001, DP014-002, DP007-001, DP056-001, DP003-001, DP050-001, DP053-001, DP054-001, and DP052-001.

The QA Inspector observed that ZPMC removed deck panels DP054-001, and DP004-001 out of New Tower Building Bay #3.

The QA Inspector was not informed by ZPMC that panels would be relocated to another location. The QA

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## WELDING INSPECTION REPORT

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Inspector was unable to perform a final V.T. of weld repairs to these deck panels prior to removal from the shop.

The QA Inspector observed ZPMC perform the first magnetic particle testing (MT) on deck panels after grinding preparation for repairs on DP014-002, DP018-002, and DP020-001.

### Summary of Conversations:

As Noted within the report shown above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Dixon,Roscoe   | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Carreon,Albert | QA Reviewer                 |

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